

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007728**Date Inspected:** 29-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Jia, Chen Ying Xin, Zhen Bo			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower and OBG Components		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following work in progress in the trial assembly area:

Section 2AW/2BW joint, panel points 16~17 - ZPMC workers performing what appeared to be final tightening of side plate T-rib flange lap plates utilizing a hydraulic wrench and using the turn of the nut method.

Section 4AW, panel points 25~26, north – ZPMC worker fitting up longitudinal diaphragm. ZPMC CWI Li Jia was present and observing the operation. The diaphragm was fitted into place and tack welded in two places.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint ESD1-FASA4-2E/E-14 located on PCMK east tower, lift 4, skin A. Welder was identified as 040775. ZPMC QC was identified as Liu Xiao Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2231-Tc-P5-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Wang Jiang Hua.

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FCAW welding of weld joints ESD1-FCSA4-2C/C-2, 3 located on PCMK east tower, lift 4, skin C. Welder was identified as 067184. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector He Gen, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2231-Tc-P5-F.

FCAW welding of weld joints ESD1-FDSA4-2D/D-19, 20 located on PCMK east tower, lift 4, skin D. Welders were identified respectively as 069073, 070046. ZPMC QC was identified as CWI Zhen Bo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2231-Tc-P5-F.

Bay 10

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

SAW welding of weld joints NSD1-FASA4-1A/C-16B, 17B located on PCMK north tower, lift 4, skin A. Welder was identified as 201750. ZPMC QC was identified as CWI Chen Ying Xin (QC3). Assisting QC3 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC3 and QC3's assistant appeared to comply with WPS-B-T-2221-Tc-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

This QA Inspector, George Goulet, asked each QC monitoring the welding if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC monitoring the welding showed this QA Inspector, George Goulet, that QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all QC observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
